

Work Order ID 66195

February 7, 2011 12:38:57 PM



Page 1

Item ID: D3248-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 2/07/11 Start Qty: 8.00



Cust Item ID:

Required Date: 2/18/11 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan: CLDate: 11/02/07 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3248

Rev A

100

0.00



PURCHASING

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: AProg Rev: A

2-Deburr if necessary

B11-2-7

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-2-7

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

ml 11 02 08 (12)

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

12 BR 11:02-9

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

ml 11 02 08 (12)

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Page 3

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Cust Item ID:

Required Date: 2/18/11 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: 44

0.00



Packaging

Memo

0.00

Packaging

11/2/11 HS (120)

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/11 HSmf

11-02-09

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Picklist Print

Page 1

February 7, 2011 12:38:57 PM

Work Order ID: 66195



Parent Item: D3248-1



Parent Item Name: Doubler

Start Date: 2/07/11

Required Date: 2/18/11

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP B 04.10.26 D3248-1 no longer made in-house.
11.02.07 now made on W.J. DD verf:JLM

IPP Rev:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.063		Purchased		No		100	sf	148.6000	0.0937	0.789053	1.3		
5052-H32 .063 Sheet													

B 11-2-7

Location

Loc Qty

Loc Code

MAT

148.6

114322

148.6

114322

12

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 106075 66195
Description: Doubler		Part Number: D3248-1
Inspection Dwg: D3248	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.50	+/-0.030	.50	✓		R.G.	
3.60	+/-0.030	3.608	✓		V	
Ø0.257	+0.005/-0.000	.260	✓		V	
Ø0.128	+0.005/-0.000	.130	✓		V	
0.38	+/-0.030	.381	✓		V	
1.000	+/-0.010	1.000	✓		V	
3.75	+/-0.030	3.752	✓		V	
0.38	+/-0.030	.378	✓		V	
R0.38	+/-0.030	.38	✓		R.G.	
2.000	+/-0.010	2.000	✓		V	
2.625	+/-0.010	2.625	✓		V	

Measured by: JB
Date: 11-2-7

Audited by: [Signature]
Date: 11-02-08

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue	KJ/JLM [Signature]	[Signature]

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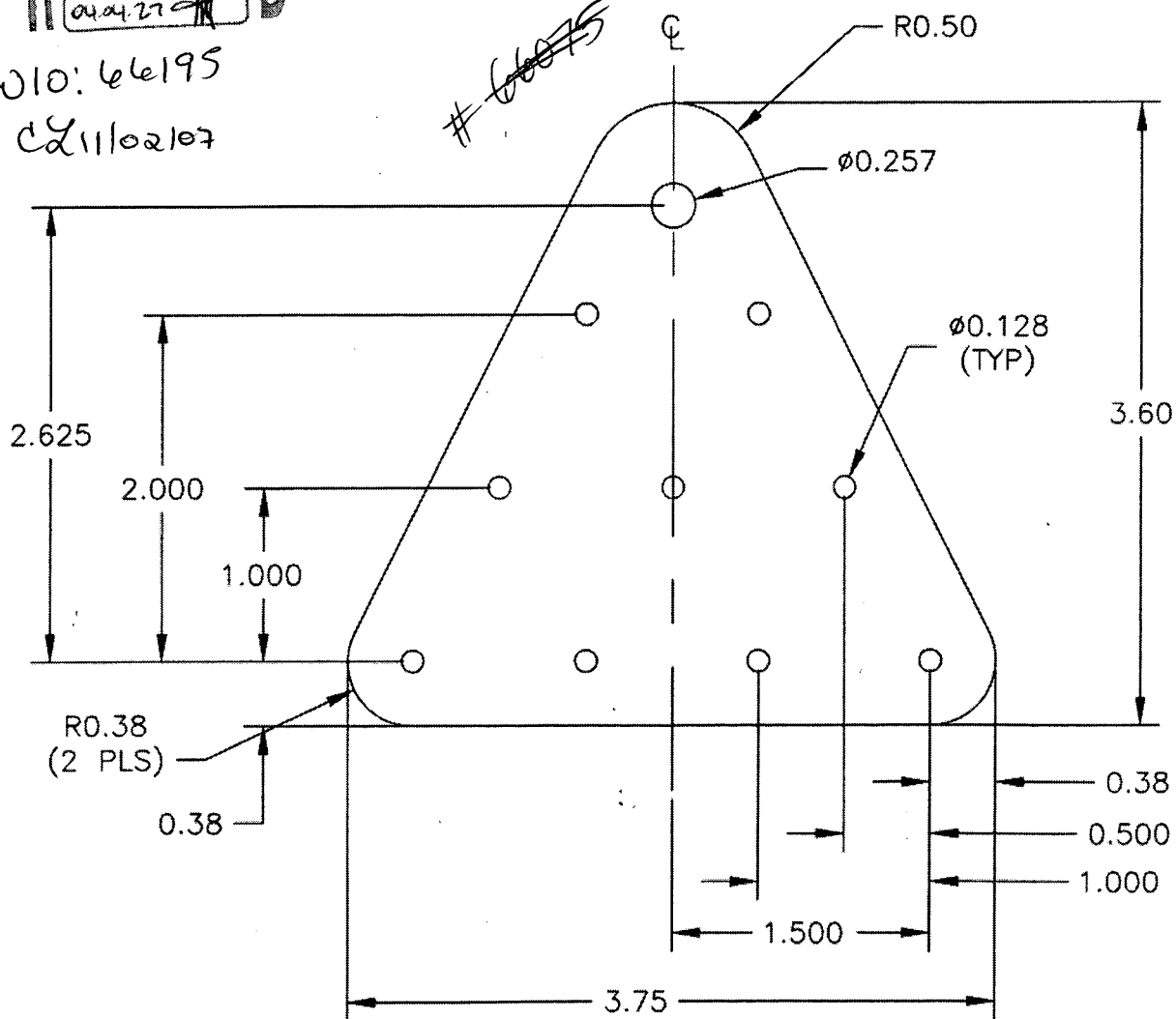
DART

DESIGN H	DRAWN BY H	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED H	DRAWING NO. D3248	REV. A SHEET 1 OF 1
DATE 04.04.06		TITLE DOUBLER	SCALE 1:1
A	04.04.06	NEW ISSUE	

RELEASED
04.04.27

W10: 66195

CZ11102107

**D3248-1****NOTE:**

- 1) MATERIAL: 5052-H32/H34 SHEET (QQ-A-250/8) 0.063 THICK (REF. DART SPEC. M5052H32S.063)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) PART IS SYMMETRIC ABOUT CENTERLINE

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